

Date: Wednesday, 3/14/2007 3:30:19 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BUSHING		
Job Number	: 31219		Part Number	: D2054		
Estimate Number	: 11965		Drawing Number	: D2054 REV B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 3/14/2007 S.O. No. : N/A		Drawing Revision	: B		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: 3/14/2007 Type : RMA		Due Date	: 3/26/2007 Qty: 100 Um: Each		
Previous Run	: N/A					
Written By	:					
Checked & Approved By	:					
Comment	: Est A1 03.01.21 Revise Dwg Rev B; added Black Teflon or Delring: Made on Cobra RF					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MDELRINR1000	Delrin Round Bar 1" 
<b>Comment:</b> Qty.: 0.0612 f(s)/Unit Total : 6.1215 f(s) Delrin Round Bar 1" Matl:Black UHMW 1" dia or black Teflon or Black Delrin Batch <u>103164</u>		
2.0	HARDINGE	HARDINGE CNC LATHE SMALL 
<b>Comment:</b> HARDINGE CNC LATHE SMALL Machine as per folio FA Deburr		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK 
<b>Comment:</b> SECOND CHECK		
5.0	PACKAGING 1	PACKAGING RESOURCE #1 
<b>Comment:</b> PACKAGING RESOURCE #1 Identify and Stock Location: <u>PC 7/4/10</u> <u>100</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/04/11  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BUSHING

Job Number: 31219

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



100%

Comment: FINAL INSPECTION/W/O RELEASE

3/14/11

Job Completion



W.D.M.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>31219</b>
<b>Description:</b> Bushing	<b>Part Number:</b>	<b>D2054</b>
<b>Inspection Dwg:</b> D2054 <b>Rev:</b> B		<b>Page 1 of 1</b>

# FIRST ARTICLE INSPECTION CHECKLIST

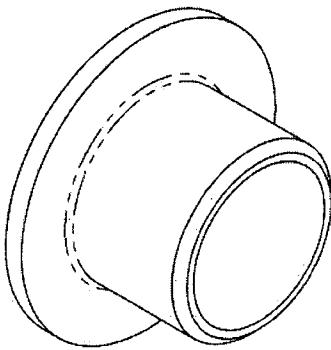
## X First Article      Prototype

Measured by:	J.L/SF	Audited by:	MS	Prototype Approval:	N/A
Date:	07/04/05	Date:	07/04/05	Date:	N/A

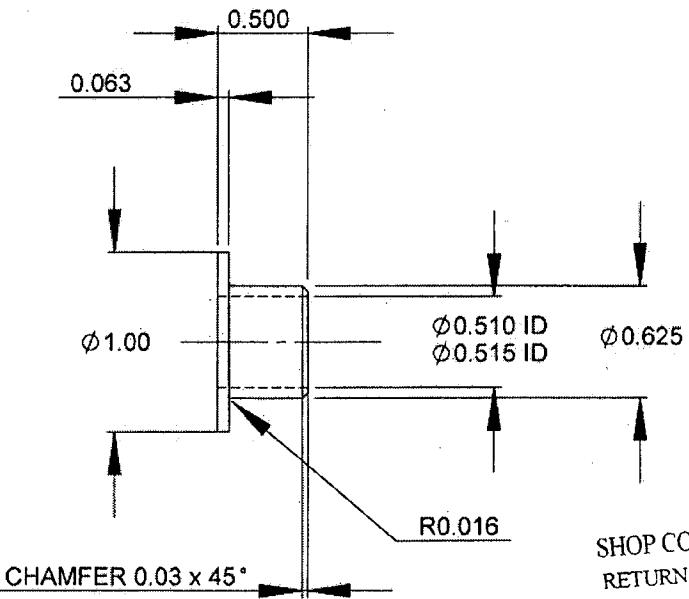
Rev	Date	Change	Revised by	Approved
A	04.06.10	New Issue	KJ/JLM	<i>[Signature]</i>

DESIGN JB	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CH</i>	APPROVED <i>CH</i>	DRAWING NO. D2054	REV. B SHEET 1 OF 1
DATE 01.12.20		TITLE BUSHING	SCALE 1:1
-	92.05.13	NEW ISSUE	
A	01.06.05	CHANGE TOL. ON ID.	
B	01.12.20	REDRAW; ADD DELRIN OPTION; ADD NOTES	

RELEASED  
01.12.21



ISOMETRIC DETAIL (SCALE 2:1)



D2054 BUSHING

MATERIAL: BLACK TEFLON  
or BLACK UHMW  
or BLACK DELRIN

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31219

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